



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

008375

D4634-043
Job Sheet 186118



Part No: D4634-043

Job Qty: 1 pcs

Part Name: Middle, Center Ceiling Panel Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/12/18

Job Tracking No:

Due Date: 12/7/18

Created By: Jesse White

Type: Stock

Description: SIOP

Note: D4634 REV.G IPP Rev. A 12/08/09 New Issue DL IPP Rev B 12/11/08 Document release DL VERIFIED
BY:JLM IPP Rev C 13/07/09 Dwg Update DL verf: DD IPP Rev D Dwg Update 13/12/23 DL IPP REV E Dwg
update 14/01/09 DL IPP Rev F Dwg. update 14/02/03 DL IPP Rev G Dwg. Update 15/01/27 DL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	12/7/18		0.00	1.00	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		DAS
							Small Fab - 4		58
							Small Fab - 5		9-89
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	1 pcs	12/7/18		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		DAS
							QC 5 - 50		APR 08 2019 40 9-89
							QC 5 - 30		
120	Packaging 3-1 - Stock - B4B	1 pcs	12/7/18		0.00	0.00	Packaging 3 - 1 - B4B		DAS
							Packaging 3 - 2 - B4B		46 APR 15 2019
							Packaging 3 - 3 - B4B		9-89
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		

					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
130 QC 21 - SA	1 pcs	12/7/18	0.00 0.00		QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21

Part Op **100** - Small Fab (Small Fab) ***BEFORE INTALLING D4728-051, APPLY A 3/16" SEEM OF PLASTIC WELD 2 BATCH
 Descriptions: TOTAL LENGHT OF PART ON EANCH SIDE OF LIGHT, LET DRY FOR ONE HOUR*** PLASTIC-WELD 2 BATCH
 : _____ 1- Assemble as per Dwg D4634-043 2- install No Smoking & seat belt symbols 3- Install led lights
 4- Install Air valves 5-Install Wiring Harness
110 - QC5 (QC5- Inspect part completeness to step on W/O)
120 - Packaging3 (Identify as per dwg & Stock Location: _____)
130 - QC21 (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
2351-20-27-C3C	Stud	2 Ea (2 ea)	100-Small Fab - 1	5007846
50-009-2	Grommet	2 Ea (2 ea)	100-Small Fab - 1	50340618
D4634-143	Middle, Center Ceiling Replacement Panel Assembly	1 pcs (1 ea)	100-Small Fab - 1	
D4646-1	Plenum Cap Assembly	2 pcs (2 ea)	100-Small Fab - 1	5138377
D4652-3	Mounting Nut	2 Ea (2 ea)	100-Small Fab - 1	
D4652-5	Air Valve, 1.25 Id Disk Type	2 Ea (2 ea)	100-Small Fab - 1	5153960
D4728-053	Cabin Lights #2	1 pcs (1 ea)	100-Small Fab - 1	5018459
PLT1.5M-M	Tie Wrap	3 Ea (3 ea)	100-Small Fab - 1	fm129712

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	2351-20-27-C3C	2	26	0
	50-009-2	2	149	0
	D4634-143	1	0	0
	D4646-1	2	32	0
	D4652-3	2	202	0
	D4652-5	2	2	0
	D4728-053	1	6	0
	PLT1.5M-M	3	2,032	0
Part Specifications				
Specifications could not be found.				

Plex 1/24/19 9:00 AM Dart.Hadley.Shannon



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Due Date: 12/7/18

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Description: SIOP

Note: D4634 REV.G IPP Rev. A 12/08/09 New Issue DL IPP Rev B 12/11/08 Document release DL VERIFIED
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update 14/01/09 DL IPP Rev F Dwg. update 14/02/03 DL IPP Rev G Dwg. Update 15/01/27 DL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	12/7/18	12/7/18	0.00	0.00	Start Up Small Fab		
100	Small Fab	1 pcs	12/7/18	12/7/18	0.00	1.00	Small Fab		
110	QC	1 pcs	12/7/18	12/7/18	0.00	0.00	QC5		
120	Packaging	1 pcs	12/7/18	12/7/18	0.00	0.00	Packaging3		
130	QC21-SA	1 Ea	12/7/18	12/7/18	0.00	0.00	QC21		

Part Op 100 - ***BEFORE INTALLING D4728-051, APPLY A 3/16" SEEM OF PLASTIC-WELD 2 ON TOTAL LENGHT OF PART
Descriptions: ON EANCH SIDE OF LIGHT, LET DRY FOR ONE HOUR*** PLASTIC-WELD 2 BATCH : _____ 1-
Assemble as per Dwg D4634-043 2- install No Smoking & seat belt symbols 3- Install led lights 4- Install Air valves 5-
Install Wiring Harness

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
2351-20-27-C3C	Stud	2 Ea (2 ea)	90-Start up Operation	
50-009-2	Grommet	2 Ea (2 ea)	90-Start up Operation	
D4634-143	Middle, Center Ceiling Replacement Panel Assembly	1 Ea (1 ea)	90-Start up Operation	
D4646-1	Plenum Cap Assembly	2 Ea (2 ea)	90-Start up Operation	
D4652-3	Mounting Nut	2 Ea (2 ea)	90-Start up Operation	
D4652-5	Air Valve, 1.25 Id Disk Type	2 Ea (2 ea)	90-Start up Operation	
D4728-053	Cabin Lights #2	1 Ea (1 ea)	90-Start up Operation	
PLT1.5M-M	Tie Wrap	3 Ea (3 ea)	90-Start up Operation	

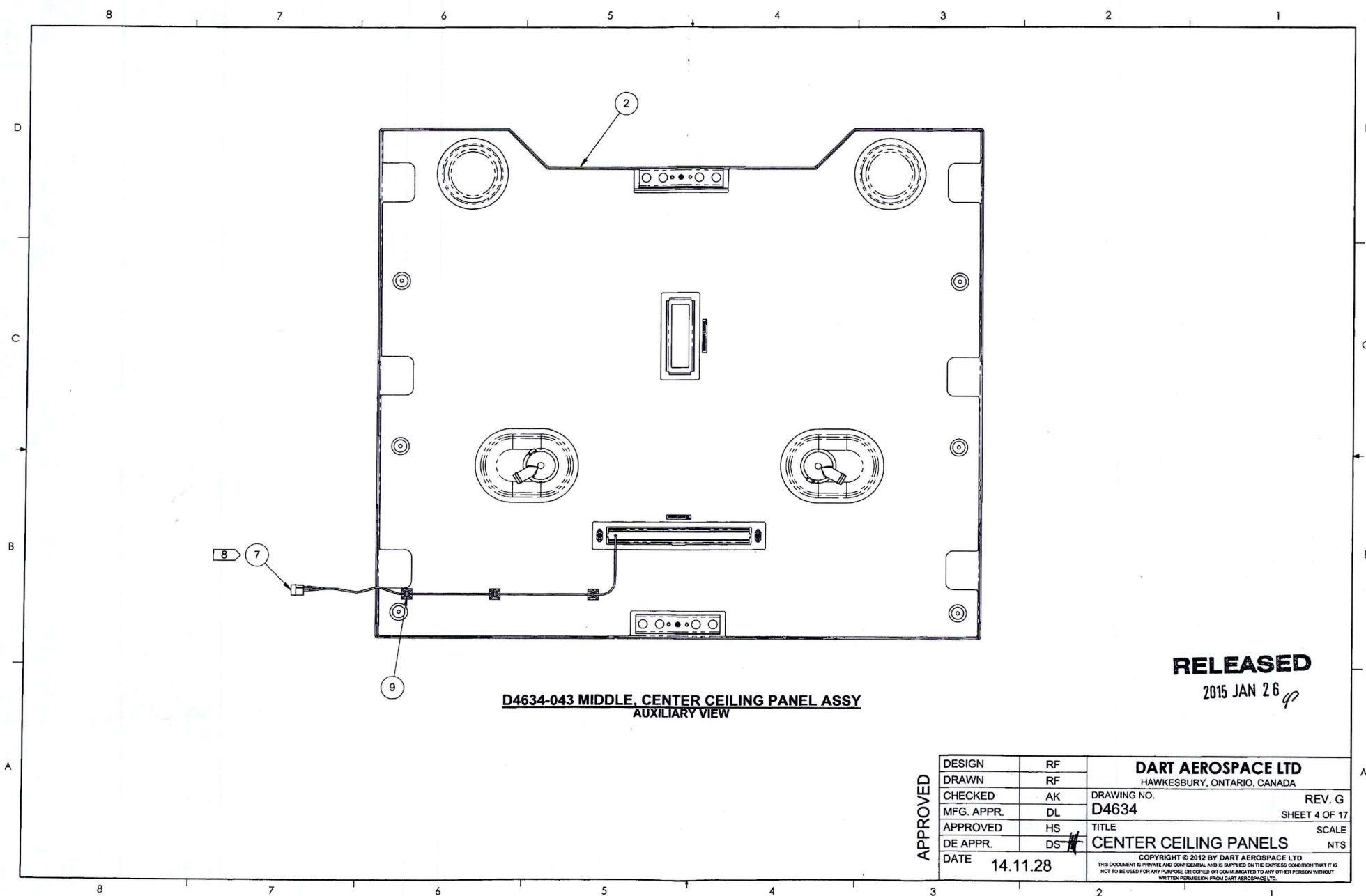
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	2351-20-27-C3C	2	37	0
	50-009-2	2	185	0
	D4634-143	1	0	0
	D4646-1	2	1	0
	D4652-3	2	207	0
	D4652-5	2	11	0
	D4728-053	1	7	0
	PLT1.5M-M	3	6	0

Part Specifications

Specifications could not be found.

Plex 11/12/18 10:20 AM dart.white.jesse



D4634-043 MIDDLE, CENTER CEILING PANEL ASSY
AUXILIARY VIEW

RELEASED
 2015 JAN 26 *q*

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	AK	DRAWING NO.	REV. G
MFG. APPR.	DL	D4634	SHEET 4 OF 17
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CENTER CEILING PANELS	NTS
DATE	14.11.28	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DART

AEROSPACE

Container No: S162338



Part: D4634-043

Job No: 186118

Serial No/Batch: S162338

Revision: G

Inspector:

Exp Date:

Instructions: Various STC's

DART Aerospace Ltd,
1320 Aberdeen Street,
Hemel Hempstead, ON K64 1K7
CANADA
TEL: 513 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/13/19